Ship Monday 24/03

Rev E DAS 14/03/26

# Work Order ID 115217

*March-18-14 11:40:24 AM*

*115217*

~~PRELIMINARY ISSUE~~

DAS 16 9-89



D4541-2

B115217

**Item ID:** D4541-2 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Bracket

**Start Date:** 3/18/14 **Start Qty:** 8.00 *8*

**Required Date:** 4/01/14 **Req'd Qty:** 8.00 *8*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** MLS **Date:** 14-03-18 **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | DAS 27 9-89 | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|---|
| **Draw Nbr** | **Revision Nbr** | | | | | | | | | |
| D4541 | PE2 | Rev E | | | | | | | | |
| 100 | | | 0.00 | | | | | | | |
| *100* | | DAS 10 9-89 | | | | | 8 | 0 | | JM 14-03-25 |
| Waterjet | **Memo** | | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1- Cut as per dwg<br>Prog rev: PE2<br>Dwg rev: PE2 | | | | | | | | | |
| | 2- Deburr | | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | | 0.00 | | | | | | | |
| *110* | | | | | | | 8 | 0 | | JM 14-03-25 |
| QC | **Memo** | | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

**Item ID:** D4541-2
**Revision ID:**
**Item Name:** Bracket
**Start Date:** 3/18/14 **Start Qty:** 8.00 *8*
**Required Date:** 4/01/14 **Req'd Qty:** 8.00 *8*
**Reference:**

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

**Cust Item ID:**
**Customer:**

Run Start *NR1*
Stop *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check<br>**Memo** | 0.00 DAS 27 9-89 14/3/25<br>0.00 | | | | 8<br>Inspect as per Dwg PEQ | | | |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location: ST531<br>**Memo** | 0.00<br>0.00 | | | 8 DAS 28 9-89 | | | MAR 2 6 2014 | |
| 160 *160* QC Quality Control | QC21- Final Inspection - Work Order Release<br>**Memo** | 0.00<br>0.00 | | | | MLJ 140326 | | | |

(121) Small Fab: Bend individual tabs as per dwg → DAS 30 9-89

DAS 10 9-89 (122) QC5 → DAS 27 9-89 14/3/25 Inspect as per Dwg PEQ

(123) Chemical conversion (8) RG 14-3-25

(124) QC7 → DAS 27 9-89 14/3/26

14/03/25 (8)

POSITIVE RECALL
EFFECTIVE 14/03/26 AUTH W
RELEASED DAS 16 9-89 DATE 14/03/26
Release Dwg as per Rev E

MF 14-3-26

DAS 27 9-89 14/3/26

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

☐ Bending
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☐ Crimp/Kink/Ripple/Wave
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☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

**General**

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
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☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

# Picklist Print

*March-18-14 11:40:27 AM*



**Work Order ID:** 115217 *115217*

**Parent Item:** D4541-2 *D4541-2*

**Parent Item Name:** Bracket

**Start Date:** 3/18/14 **Required Date:** 4/01/14

**Start Qty:** 8.00 **Required Qty:** 8.00

**Comments:** IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP REV:D 13.04.23 as per dwg revD DD verf:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| M6061T6S.032 | | Purchased | No | | | 100 | sf | 410.6032 | 0.416 | 4 | | | |
| *M6061T6S.032* | | | | | | | | | ** | | | | |
| 6061-T6 Sheet 0.032" | | | | | | | | | | | | | |

JM 14-03-25

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| MAT021 | 410.60317 | | |
| 123483 | 8.57 | | |
| m125822 | 17 | | |
| m127272 | 128.75317 | | |
| m128054 | 256.28 | | 128054 |

DQA: _____ Date: _____

DART AEROSPACE

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

| DART AEROSPACE LTD | Work Order: | 115217 |
|---|---|---|
| | | |
| **Description:** Bracket | Part Number: | D4541-2 |
| | | |
| **Inspection Dwg:** D4541 **Rev:** ~~B~~ B2 | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| Ø0.098 | +0.004/-0.001 | 0.099" | — | | V | JKmos |
| Ø0.257 | +0.006/-0.001 | 0.258" | — | | V | |
| 1.00 | +/-0.030 | 1.005" | — | | V | |
| 0.688 | +/-0.010 | 0.690" | — | | V | |
| 0.344 | +/-0.010 | 0.346" | — | | V | |
| 0.312 | +/-0.010 | 0.312" | — | | V | |
| 0.26 | +/-0.030 | 0.267" | — | | V | |
| 1.09 | +/-0.030 | 1.096" | — | | V | |
| ~~0.60~~ 0.80" | +/-0.030 | 0.796" | — | | V | |
| 0.320 | +/-0.010 | 0.320" | — | | V | |
| ~~1.45~~ 1.65" | +/-0.030 | 1.647" | — | | V | |
| 19.~~5~~ | +/-0.100 | 19.5" | — | | T | JKmos |
| 30.1 | +/-0.100 | 30.1" | — | | T | |
| 0.032 | +/-0.010 | 0.031" | — | | V | |

| Measured by: | JM | Audited by: | | Preliminary Approval: | |
|---|---|---|---|---|---|
| Date: | 14-03-25 | Date: | MAR 25 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 12.05.15 | New Issue | KJ | |
| B | 13.02.27 | Dimensions revised | KJ | |
| C | 13.05.08 | Dwg Rev updated | KJ | |

DQA: _____ Date: _____

# WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

**AGAINST DEPARTMENT/PROCESS**

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

| Root Cause | | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Design | ☐ | | | | | | | | | |
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Handling/Pre | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Offset/Setup | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Transport | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

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☐ Inspection Incomplete/Unqualified
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☐ Out of Sequence
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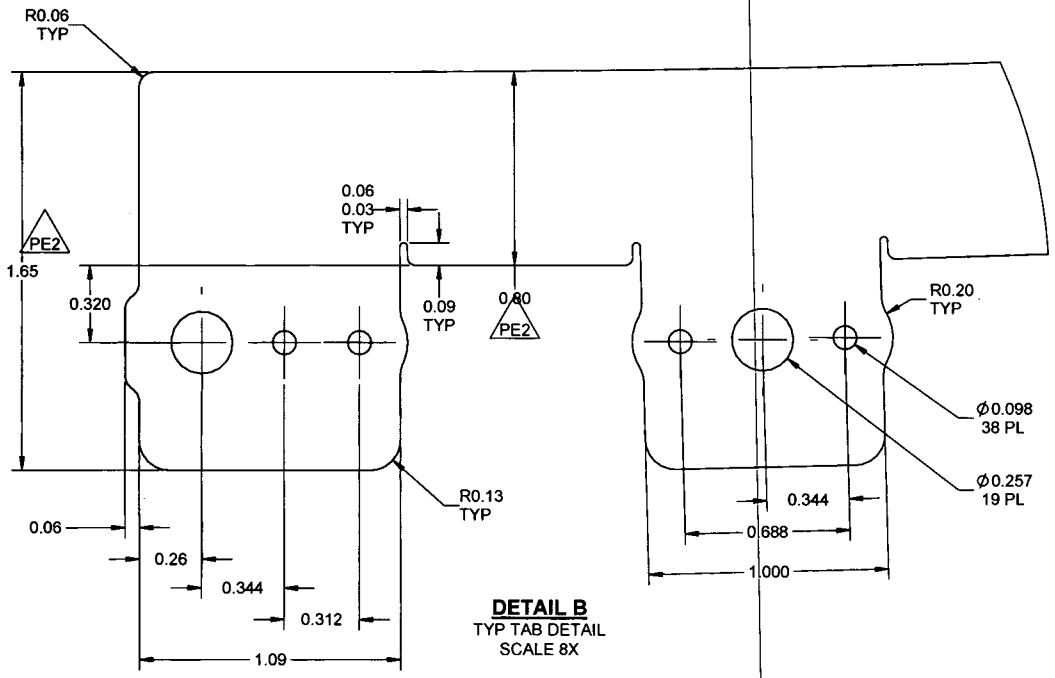
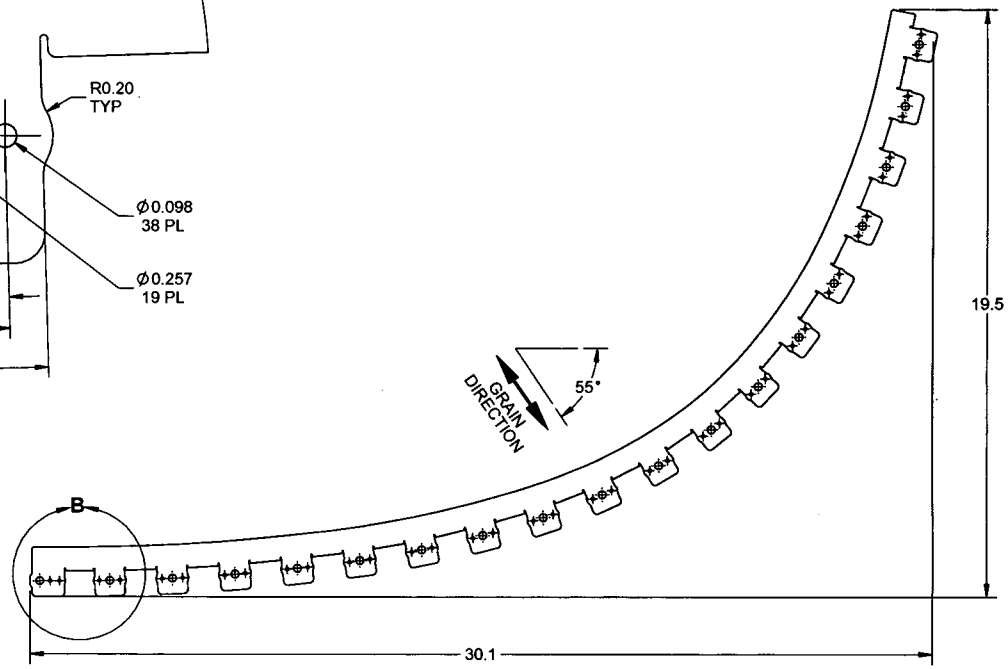
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____




**DETAIL B**
TYP TAB DETAIL
SCALE 8X




**D4541-2F BRACKET** PE2
(FLAT PATTERN)

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.14 lbs
8) PROFILE PER DRAWING FILE "D4541-2F-REVE.DXF"

PRELIMINARY E2
14.03.07 (AJS)

| | | |
|---|---|---|
| DESIGN | CP | **DART AEROSPACE LTD** |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4541 — REV. PE2 |
| MFG. APPR. | | SHEET 4 OF 13 |
| APPROVED | | TITLE BRACKET — SCALE NTS |
| DE APPR. | | |
| DATE | 14.03.07 | |

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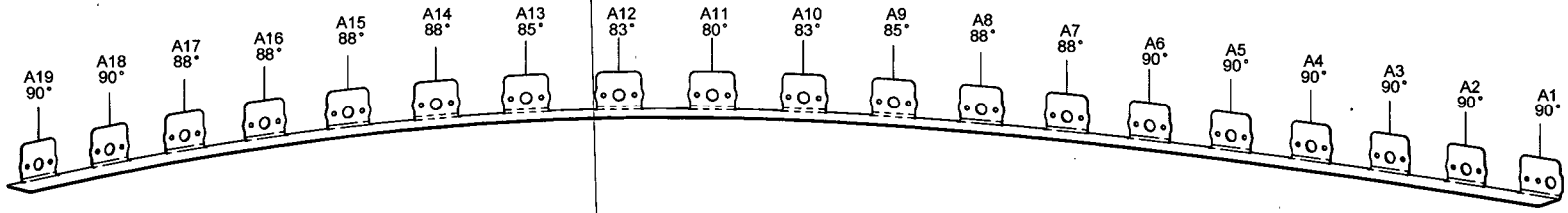
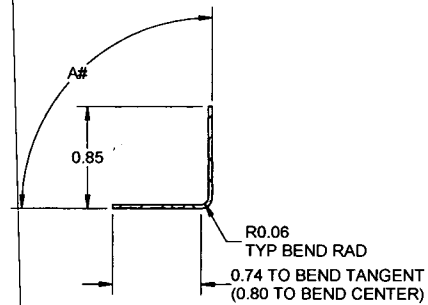



## D4541-2 BRACKET PE2




PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: MAKE FROM D4541-1F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.15 lbs
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

| | | |
|---|---|---|
| DESIGN | CP | **DART AEROSPACE LTD** |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4541 — REV. PE2 |
| MFG. APPR. | | SHEET 3 OF 13 |
| APPROVED | | TITLE: BRACKET — SCALE: NTS |
| DE APPR. | | |
| DATE | 14.03.07 | |

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# DART AEROSPACE LTD

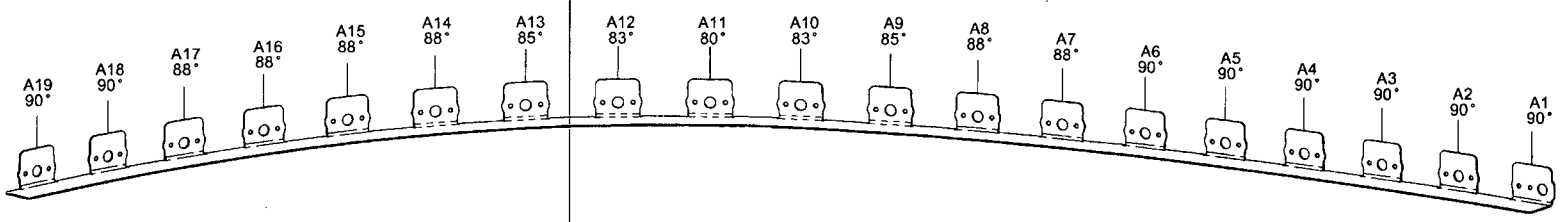
Description: Bracket Work Order: 115217

Inspection Drawing: D4541 Rev: PE2 Part Number: D4541-2

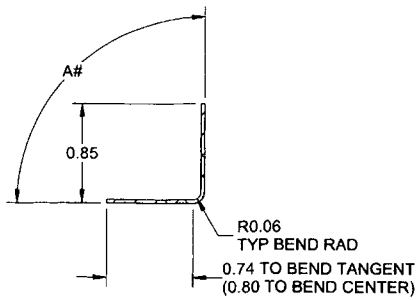
## INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| .85 | +/- .030 | .856 | / | | V SB-11 | SB-11 |
| .74 | +/- .030 | .747 | / | | V | SB-11 |
| 90° | +/- .030 | 90° | / | | angle Protractor | SB - 7 |
| 88° | +/- .030 | 88° | / | | angle Protractor | SB - 7 |
| 85° | +/- .030 | 85° | / | | " | SB - 7 |
| 83° | +/- .030 | 83° | / | | " | SB - 7 |
| 80° | +/- .030 | 80° | / | | " | SB - 7 |

| Measured by: DAS 30 9-89 | Checked By: DAS 36 9-89 | QC inspector: | Engineering Approval (*if necessa* |
|---|---|---|---|
| Date 14/03/25 | Date 14/03/25 | Date | Date |




## D4541-2 BRACKET (E)




RELEASED
[illegible] 2014-05-26

NOTES:
1) MATERIAL: MAKE FROM D4541-2F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.15 lbs
8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

| | | |
|---|---|---|
| DESIGN | CP | DART AEROSPACE LTD |
| DRAWN | A.S | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4541 REV. E |
| MFG. APPR. | | SHEET 3 OF 13 |
| APPROVED | | TITLE BRACKET SCALE NTS |
| DE APPR. | | |
| DATE | 14.03.07 | |

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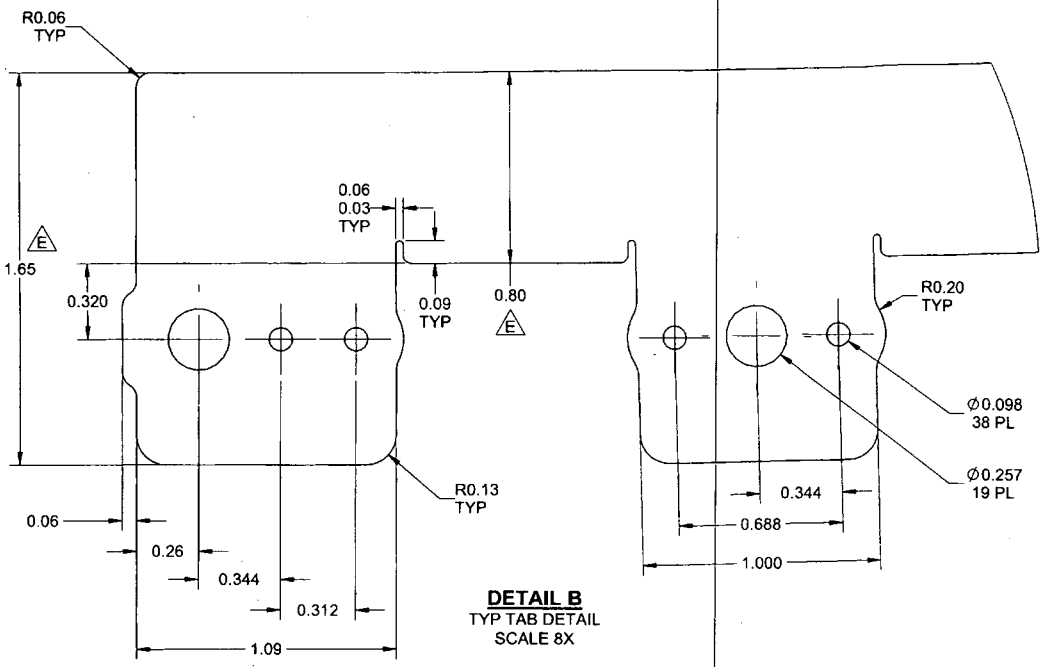
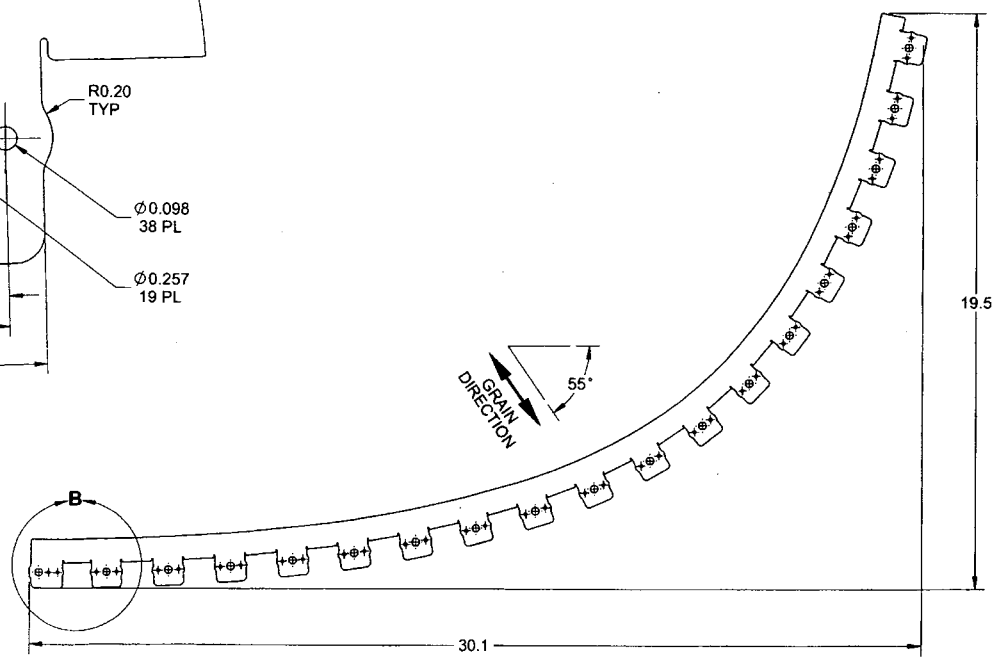



**DETAIL B**
TYP TAB DETAIL
SCALE 8X




**D4541-2F BRACKET** E
(FLAT PATTERN)

RELEASED
2014-03-26

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.14 lbs
8) PROFILE PER DRAWING FILE "D4541-2F-REVE.DXF"

| | | |
|---|---|---|
| DESIGN | CP | **DART AEROSPACE LTD** |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D4541 REV. E |
| MFG. APPR. | | SHEET 4 OF 13 |
| APPROVED | | TITLE BRACKET SCALE NTS |
| DE APPR. | | |
| DATE | 14.03.07 | |

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